

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021762**Date Inspected:** 13-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Mai Quin Li**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Steel Barriers Bottom Plate**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld identified as W5-SB41A-001-127, located on Steel Barrier, W5-SB41A-001. Welder is identified as 206296. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld identified as W5-SB37-001-126, located on Steel Barrier, W5-SB37-001. Welder is identified as 048625. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld identified as W5-SB37-001-126, located on Steel Barrier, W5-SB37-001. Welder is identified as 048625. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld identified as W5-SB42-001-128, located on Steel Barrier, W5-SB42-001. Welder is identified as 201074. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables

WELDING INSPECTION REPORT

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recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld identified as W5-SB33A-001-128, located on Steel Barrier, W5-SB33A-001. Welder is identified as 201889. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld identified as W5-SB40-001-084, located on Steel Barrier, W5-SB40-001. Welder is identified as 062092. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld identified as E2-SB25D-001-013, located on Steel Barrier, E2-SB25D-001. Welder is identified as 201888. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

SMAW welding of weld identified as E2-SB30-001-004, located on Steel Barrier, E2-SB30-001. Welder is identified as 201888. ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

Bay #16

NDT

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08526.

This QA inspector performed Ultrasonic Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as item #1, SEG3007P-078/080/187/192/ 202/197/085/ 087/092/098. Item # 8, SEG3007P-033/043/037/038/047/048/051/052/059/ 060/063/064/067 /068/160/162 /164/168/170/172/174/176/178/180/182. No indications in the area tested were found.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey, Delbert
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Quality Assurance Inspector

Reviewed By:	Hall, Steven
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QA Reviewer
